

Date: Monday, 08/06/2009 1:12:15 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GUIDE TOOL
Job Number : 48419	
Estimate Number : 13014	
P.O. Number :	Part Number : D36571
This Issue : 08/06/2009 S.O. No. :	Drawing Number : D3657 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 34550	Material :
Written By :	Due Date : 15/06/2009 Qty: 12 Um: Each
Checked & Approved By : <u>JUD 09.06.08</u>	
Comment : Est Rev:A New Issue 07-01-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X01000	6061-T6 Bar .500 x 1.00
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Comment: Qty.: 0.2012 f(s)/Unit Total : 2.4142 f(s)

6061-T6 Bar .50" x 1.0"

Batch: M1107438mmf 09/06/11

(12)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank 2.300 " long

mmf 09/06/11

(12)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA669Rev: AA & Dwg D3657 Rev: A

2-Deburr per dwg D3443

mmf 09/06/12

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 09/06/12

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

M.A 09/06/17

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/06/2009 1:12:15 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE TOOL

Job Number: 48419

Part Number: D36571

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

el

09-06-17

(X12)

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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(12)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BT 09-06-17

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: ST 243

SS

09/06/18

9.0	QC21	FINAL INSPECTION/W/O RELEASE
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09/06/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 9-06-18

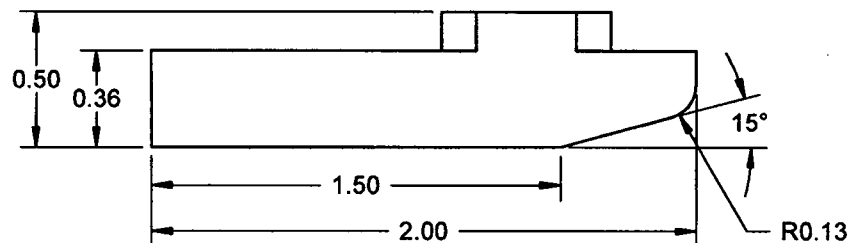
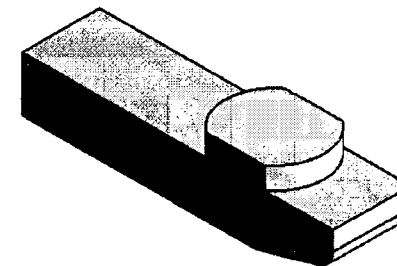
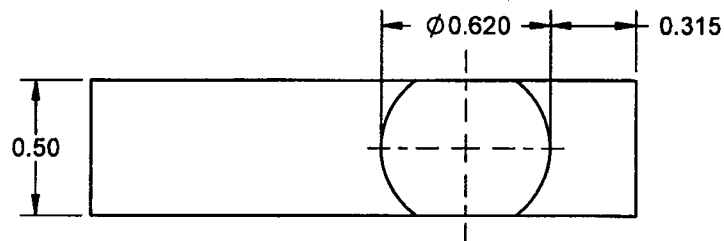
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D3657-1 GUIDE TOOL
(WAS GENEVA P/N G12170)**

RELEASED
07.09.07

NO. 18819
WORK ORDER
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651-T6510-T6511-T62) ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3657-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.04 lbs

A	NEW ISSUE; REPLACES G12170	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	CLB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	CE		
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	E	D3657	SHEET 1 OF 1
APPROVED	AP	TITLE	SCALE
DE APPR.		GUIDE TOOL	3:2
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	